

Date: Wednesday, 13/02/2008 7:19:18 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: STEP WELDMENT RE-WORK
Job Number	: 37393		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D34631
This Issue	: 13/02/2008 S.O. No. :	Drawing Number	: D3463-1
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 19/02/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
PULL FROM STOCK
2x D3463-1 B35881

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

FILL WITH WELD THREE Ø0.125 HOLE THAT WERE DRILLED
WRONG AND ONE CENTER PUNCH MARK, REF. DRAWING D3463-1.

ROD SS 316 1/4 BATCH M105524

GRIND FLUSH AND BUFF.

FC 08/02/13 (2)

3.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

D 0802-13 (2)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08/02/13 (2)

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

DRILL AS PER DRAWING D3463-1, ONE Ø0.125 HOLE AT 0.610"
FROM END OF LONG LEG, ONE SIDE ONLY.

08/02/21
08/02/19 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: ~~Yes~~ Date: 02/02/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP WELDMENT RE-WORK

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Job Number:



Seq. #:

Machine Or Operation:

Description :

DE-BURR

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



08/02/21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/02/19

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/02/21

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

USING NEW B/N

Location: 57205

08/2/22 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/22

Job Completion



08/2/22

(2)

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

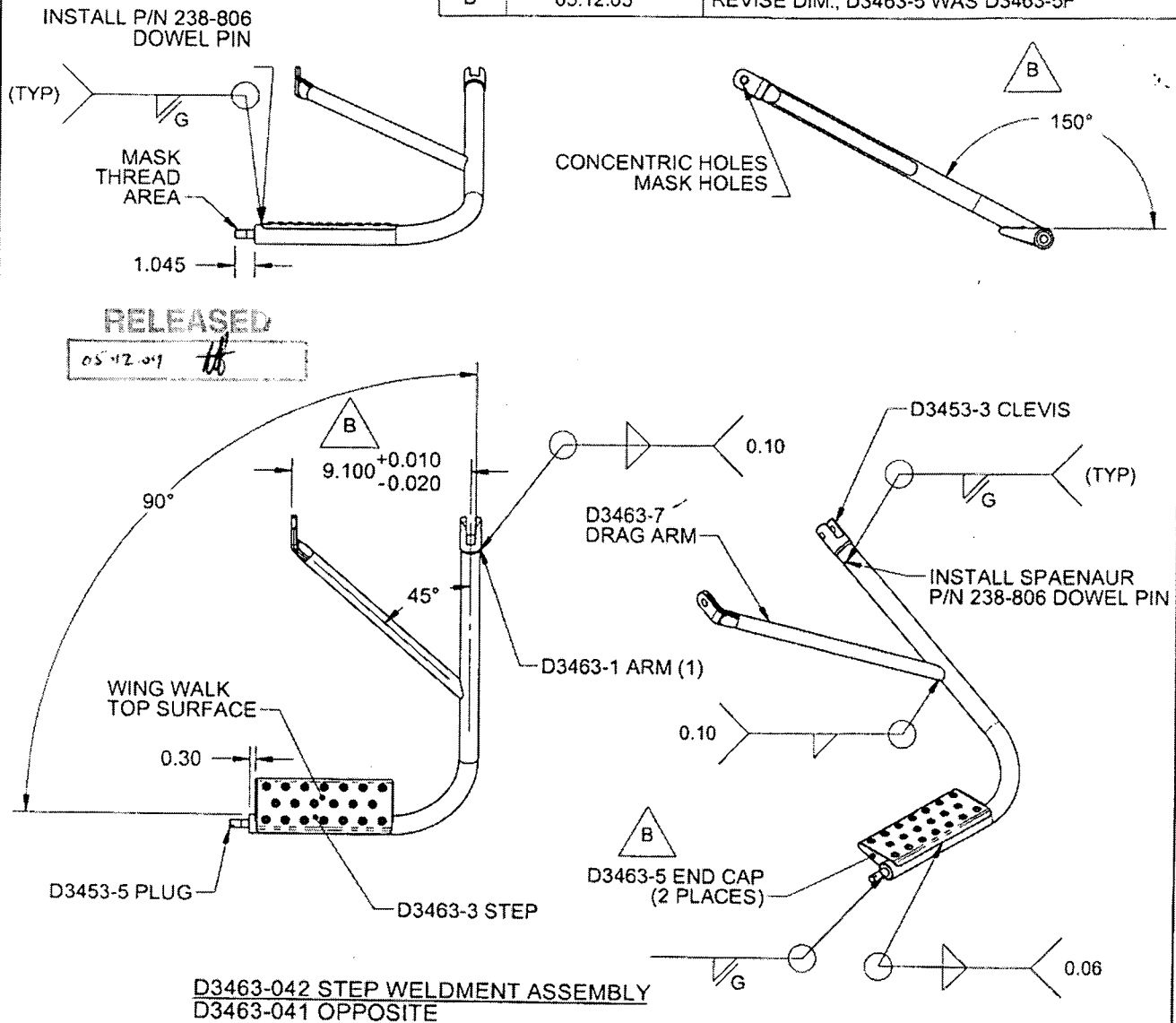
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ##	APPROVED ##	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

w/o 37393

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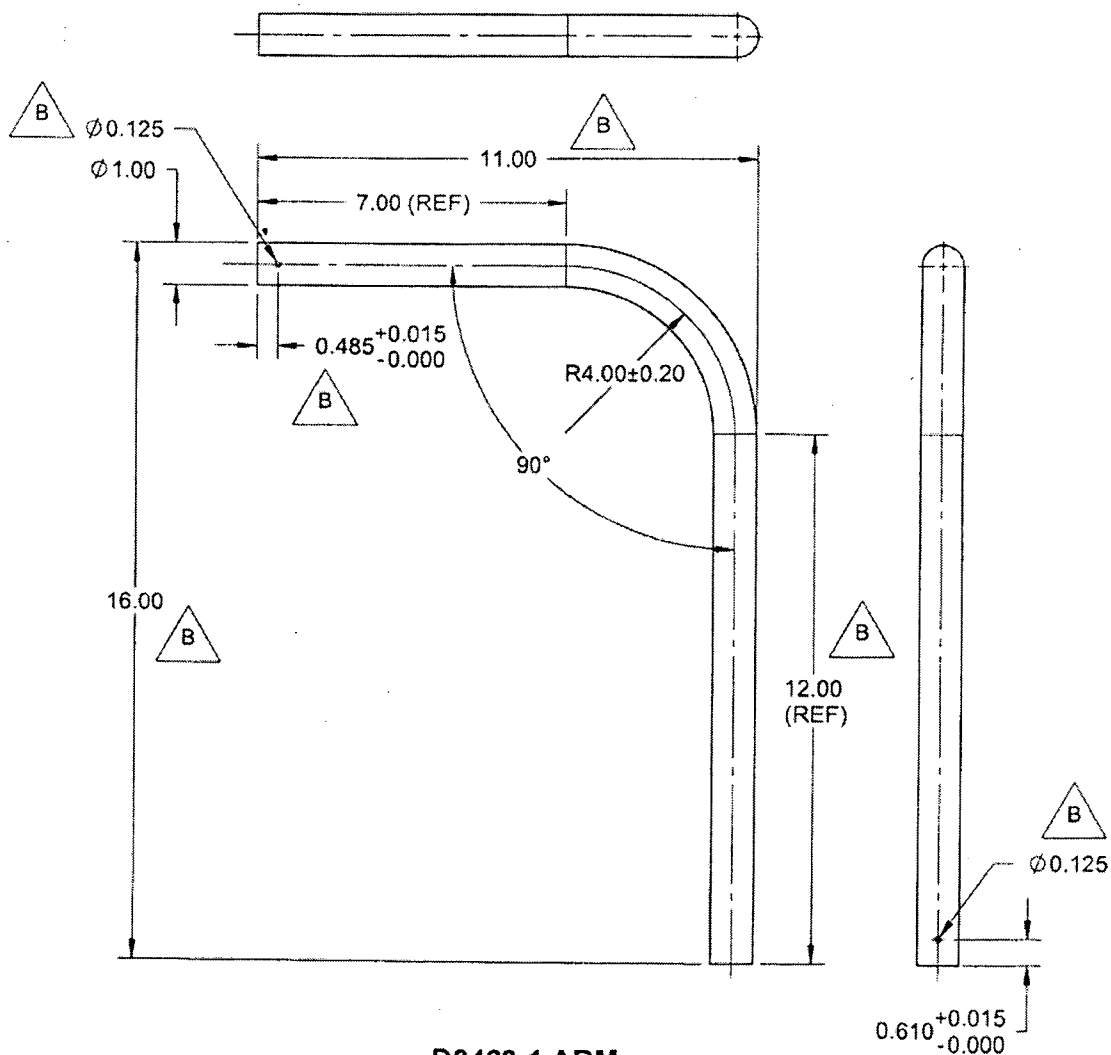
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 [Signature]

**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

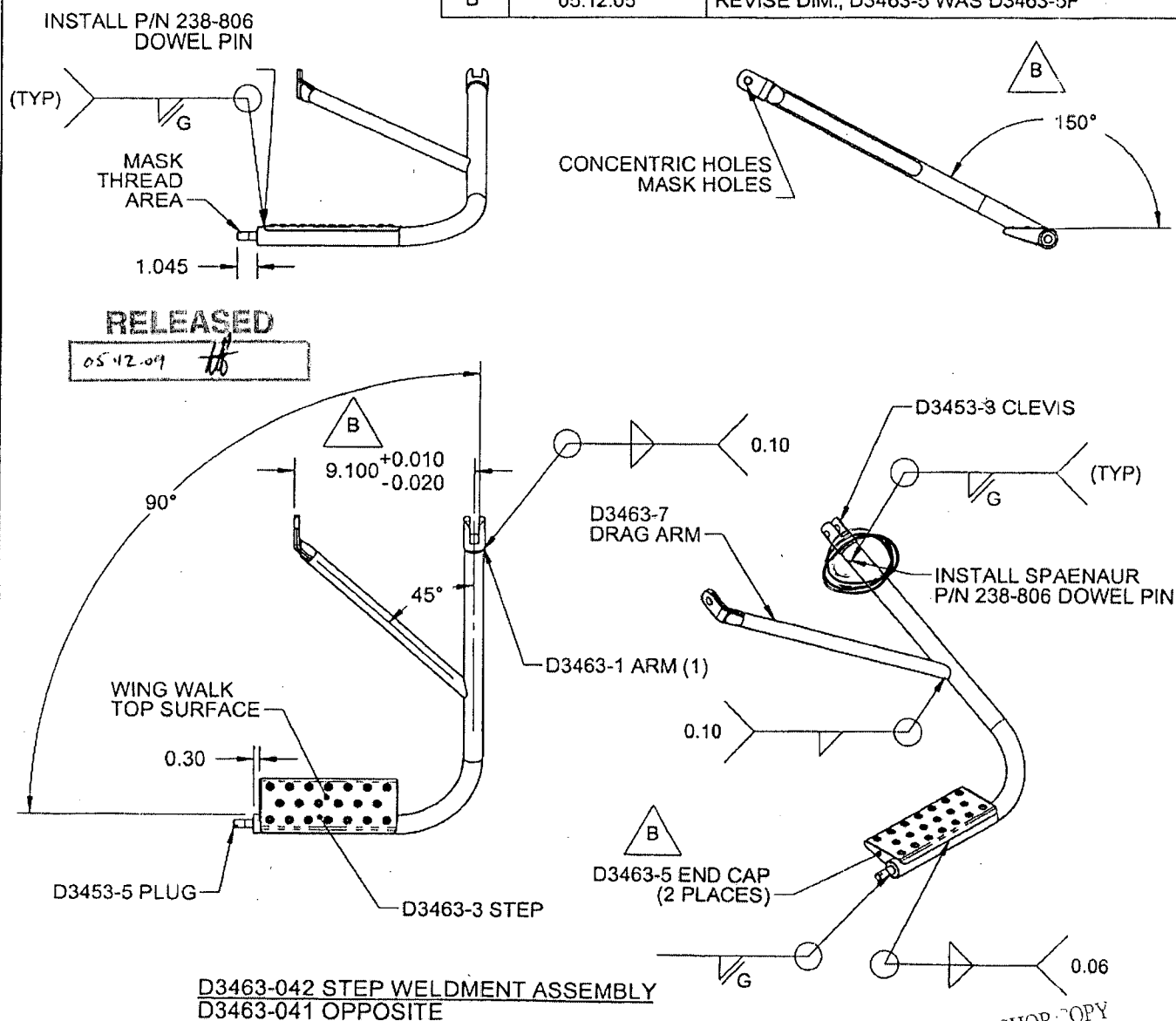
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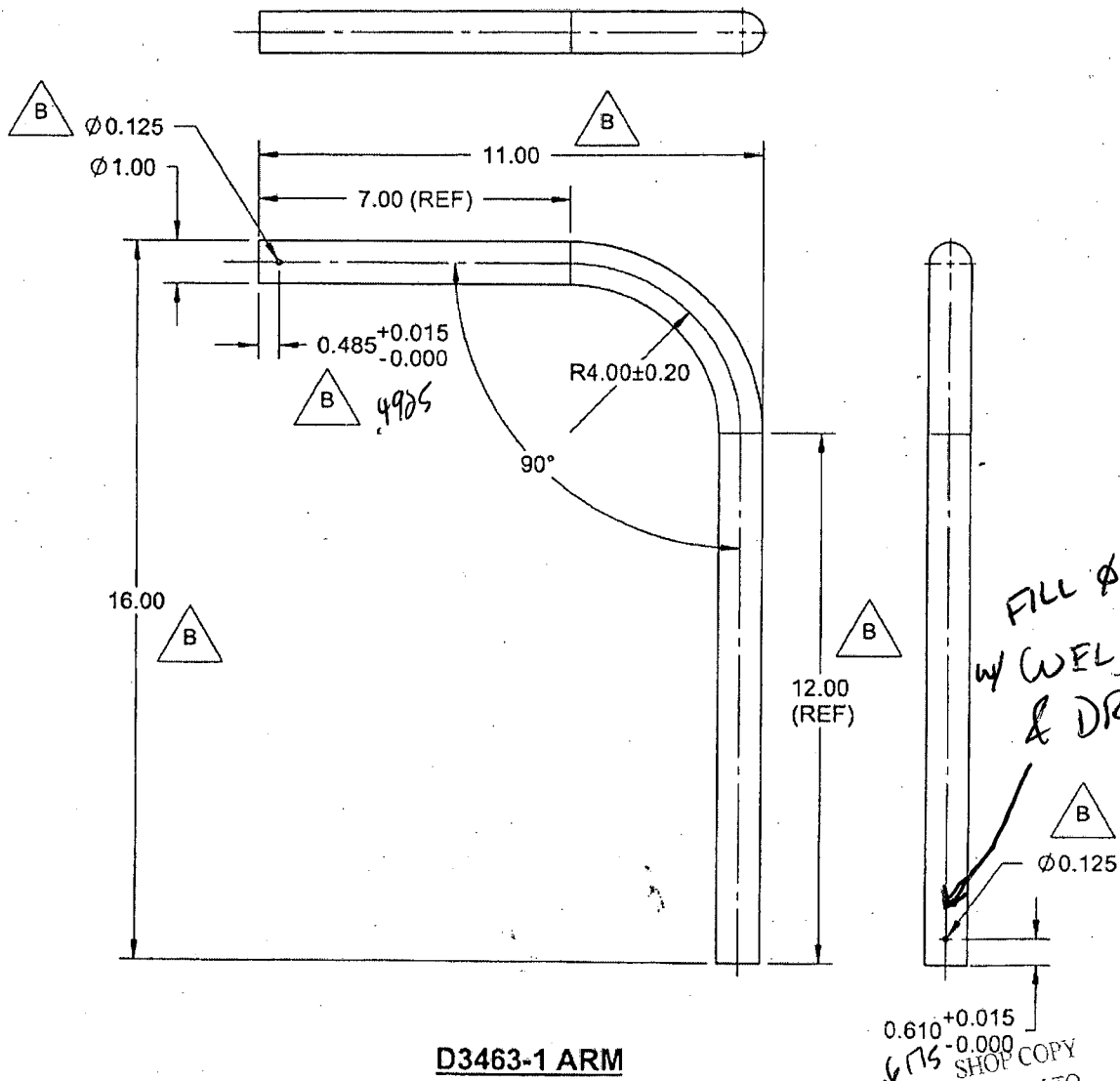
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DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 *[Signature]*



D3463-1 ARM

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0.610 +0.015 / -0.000
6.75
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08.02.12
-0625